

Work Order ID 69766

Wednesday, May 18, 2011 3:41:04 PM



~~SHIP 20~~

Page 1

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket

Stop



Start Date: 5/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date:

11/05/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	A

100 : 0.00



DOCUMENT CONTROL

DC

Memo

Document Control

Photocopy bluefile & type labels per PPPD350-607-043 CHG005
PRINT DWG PAGE: 41/42 OF 162

Handwritten signature

110



Pick Kit

Packaging

Memo

Packaging

120



Small Fab

Small Fab

Memo

Small Fab

Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291
Batch: *M116945*
Exp Date: *12/01/15*

Handwritten signature *11/06/08*

Handwritten signature *11/06/29* *①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69766

Wednesday, May 18, 2011 3:41:04 PM

Page 2

Item ID: D350-607-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Utility-Basket

Start Date: 5/18/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69766

Wednesday, May 18, 2011 3:41:04 PM



Page 3

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 5/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-043

Location: _____

170

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

MF

11-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 18, 2011 3:41:09 PM

Page 1

Work Order ID: 69766

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket



Start Date: 5/18/2011

Required Date: 5/24/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
 IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
 per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2728-3		Manufactured	No			110	Each	0.0000	2	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Dart Logo label

D350-607-241		Manufactured	No			140	Each	2.0000	1	1			
--------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Basket Clamp Assembly

CHC7001

Location

Loc Qty

Loc Code

FG022

2

69365

2

D2022-101

Manufactured No

110

Each

28.0000

5

5

Spacer

Location

Loc Qty

Loc Code

ST504

28

67768

28

D2221

Manufactured No

110

Each

0.0000

1

1

350 Basket Base

D2258-200

Manufactured No

110

Each

12.0000

1

1

Placard 200lb

Location

Loc Qty

Loc Code

ST505

12

64284

2

68928

10

115050 JB

69355 11/6/29

JB E

67768

11/06/29

JB 11/06/08

68928

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 2

Work Order ID: 69766

Parent Item: D350-607-043











Parent Item Name: Heli-Utility-Basket

Start Date: 5/18/2011

Required Date: 5/24/2011

Start Qty: 1.00

Required Qty: 1.00

D2332-041	Manufactured	No	110	Each	4.0000	1	1	✓	
							69600	JB	E
Lid Prop Assembly 6.69" long									
			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>		
			st512			4			
			68830			4			
D2530	Manufactured	No	110	Each	7.0000	1	1	✓	
							69907	JB	W
Handle Weldment									
			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>		
			ST506			7			
			66563			1			
			68363			6			
D2535	Manufactured	No	110	Each	39.0000	2	2	✓	
								JB	W
Spring									
			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>		
			ST504			39			
			66764			39			
D2537	Manufactured	No	110	Each	30.0000	2	2	✓	
							66764	JB	W
Bushing									
			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>		
			ST504			30			
			66972			30			
D2931	Manufactured	No	110	Each	668.0000	2	2	✓	
							66972	JB	W
Bumper									
			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>		
			ST504			668			
			46064			668			
							46064		

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 18, 2011 3:41:10 PM

Work Order ID: 69766

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 5/18/2011

Required Date: 5/24/2011

Start Qty: 1.00

Required Qty: 1.00

D2989-041 Manufactured No



Basket Lid Assembly

D2989-043 Manufactured No



Basket Lid Assembly

AN3-16A Purchased No



Bolt

110 Each

0.0000

1

B 70111



1

EB 11/06/29

110 Each

0.0000

1

B 70112



1

EB 11/06/29

110 Each

149.0000

2



2

116419 JB

Location

Loc Qty

Loc Code

ST352

149

116419

49

117441

100

AN4-13A Purchased No



Bolt

110 Each

245.0000

2



2

117962 JB

Location

Loc Qty

Loc Code

ST357

245

117628

245

AN4-22A Purchased No



Bolt

110 Each

235.0000

7



7

11/06/08

Location

Loc Qty

Loc Code

ST359

235

114784

85

116419

50

117313

100

114784

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 18, 2011 3:41:10 PM

Page 4

Work Order ID: 69766

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 5/18/2011

Required Date: 5/24/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No
Bolt

110 Each 108.0000 4

4 ✓ ✓

Location	Loc Qty	Loc Code
ST339	108	
116590	28	
117313	30	
117619	50	

JB

MS20600-AD4W3 Purchased No
Cherry Rivets

110 Each 1,355.000 2

2 ✓

Location	Loc Qty	Loc Code
ST321	1030	
111636	330	
117505	500	
117601	200	
WA018	325	
107939	325	

JB

AN960JD416 NAS1149D0463J Purchased No
Washer

110 Each 0.0000 14

14 ✓

Location	Loc Qty	Loc Code
FP-B	3	
110153	3	

117460 JB

AN960JD416L NAS1149D0416J Purchased No
Washer

110 Each 3.0000 2

2 ✓

116513 JB

AN960JD516 NAS1149D0563J Purchased No
Washer

110 Each 0.0000 4

4 ✓

117291 11/06/08

Wednesday, May 18, 2011 3:41:10 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 18, 2011 3:41:10 PM

Work Order ID: 69766

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 5/18/2011

Required Date: 5/24/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832J Purchased

No

110

Each

0.0000

2

2

✓



Washer

NAS1515H4

Purchased

No

110

Each

192.0000

2

2

✓



Washer

Location

Loc Qty

Loc Code

ST277

192

111525

2

116169

40

117460

50

117735

100

116169

AN970-4

Purchased

No

110

Each

95.0000

4

4

✓



Washer

Location

Loc Qty

Loc Code

ST344

14

115936

14

ST349

81

116900

31

117317

50

117317

MS21042L3

Purchased

No

110

Each

2,188.000

2

2

✓



Nut

Location

Loc Qty

Loc Code

ST300

2188

116391

11

116540

211

116549

766

117441

800

117601

400

116549

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 18, 2011 3:41:11 PM

Work Order ID: 69766

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 5/18/2011

Required Date: 5/24/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,815.000

9

9

✓



JB *C*

Nut

Location

Loc Qty

Loc Code

ST300

4815

116823

1015

117441

3000

117601

800

116823

MS21042L5

Purchased

No

110

Each

1,251.000

4

4

✓



JB *11/06/08*

Nut

Location

Loc Qty

Loc Code

ST300

1251

116105

291

116548

260

117441

500

117591

100

117611

100

116105

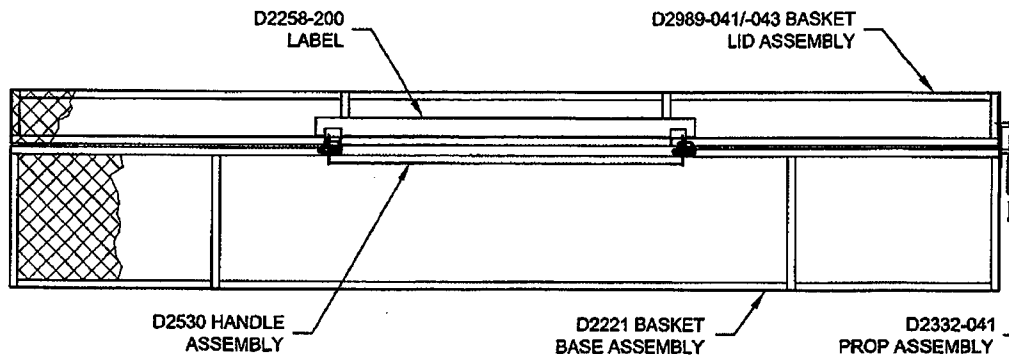
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

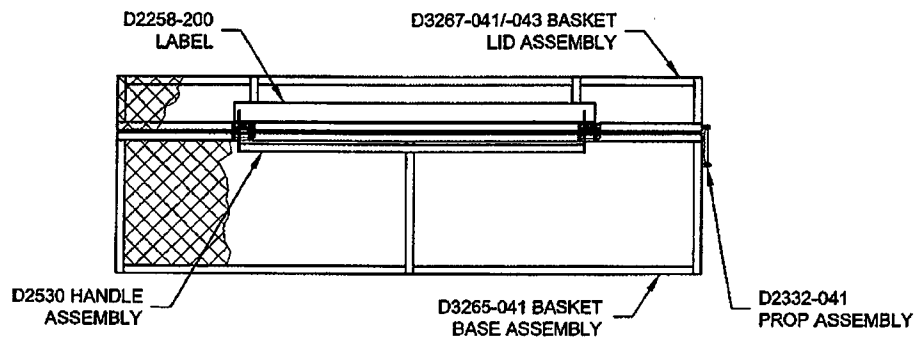
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

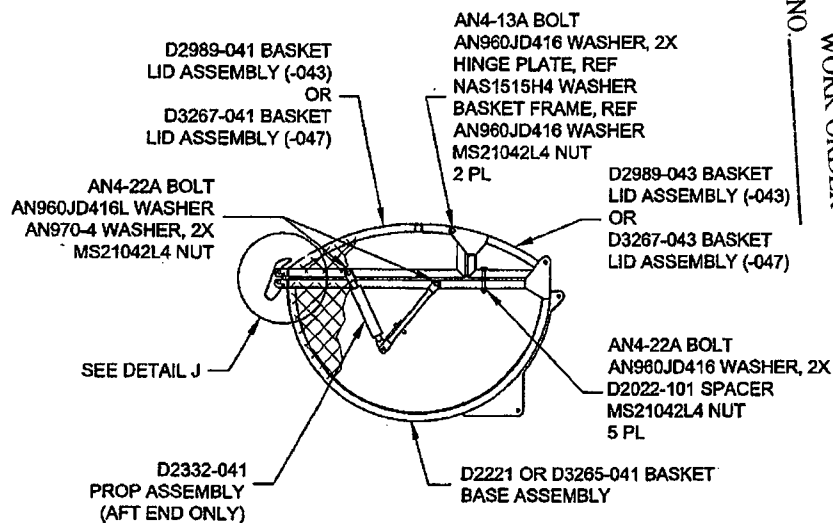
NOTE: Date & initial all entries



D350-607-043 HELI-UTILITY- BASKET™



D350-607-047 HELI-UTILITY- BASKET™



**VIEW C-C
PROP ARM DETAIL**

Figure 6— Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

NO
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

69766
P/11050

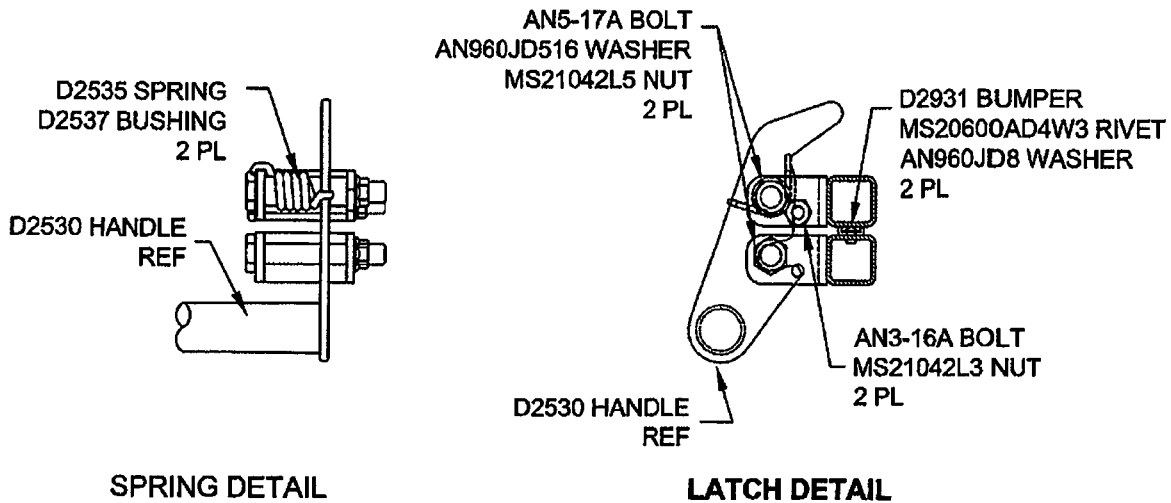
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

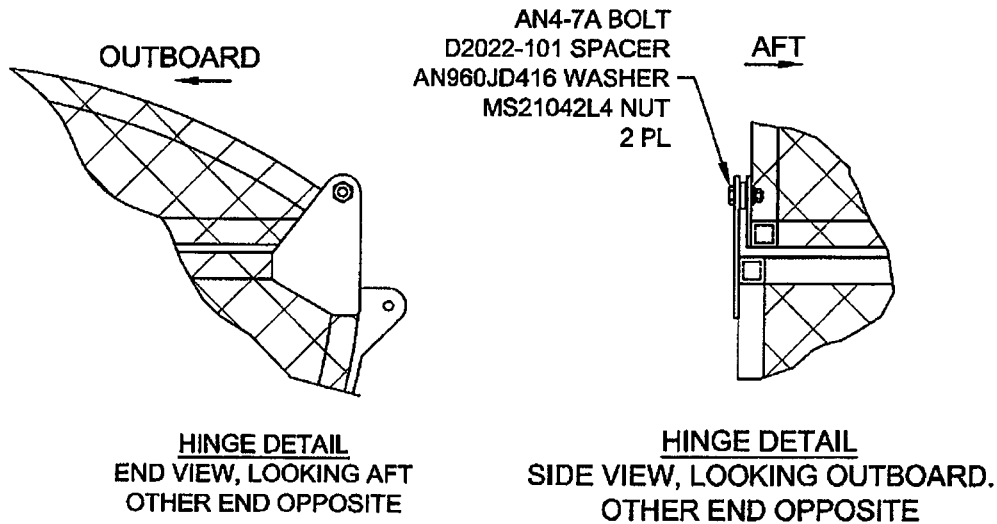
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DETAIL J:
HANDLE WELDMENT

u/s barrel



DETAIL H:
HINGE

Figure 7 – Basket Replacement Parts

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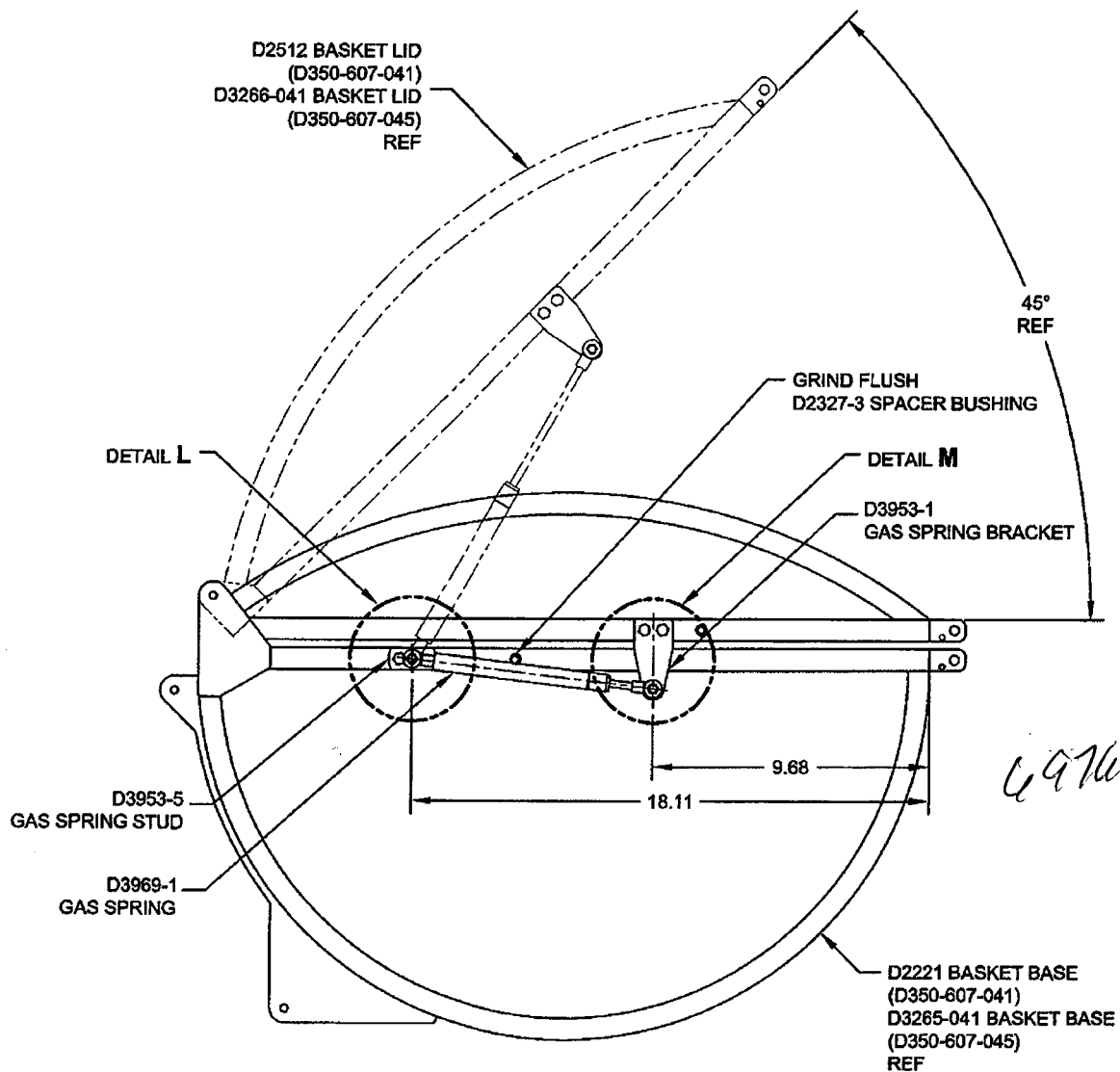
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-607-141 AUTOMATIC LID OPENER INSTALLATION
(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION
(1 END ONLY)

Figure 8a – Automatic Lid Opener Installation

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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